

Date: Monday, 1/14/2008 2:37:31 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW
Job Number : 36750	
Estimate Number : 10495	
P.O. Number :	Part Number : D2360
This Issue : 1/14/2008 S.O. No. :	Drawing Number : D2360REVD,D2341REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : D/F F 08/04/15
Previous Run : 33778	Material :
Written By :	Due Date : 1/31/2008 Qty: 4 Um: Each
Checked & Approved By :	
Comment : est rev H 07/06/12 ecn 825 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6201	T Extrusion 4X4X3/8
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Comment: Qty.: 1.1067 f(s)/Unit Total : 4.4268 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)

Batch: ~~B35952~~ B35952

08/02/03

(4)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 12.65" Long

08/02/03

(4)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2341 and Dwg D2341

J.L 08/02/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/02/10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Deburr and Tumble

J.L 08/02/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:37:31 PM
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Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

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Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2-02-11

(4)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-02-12

(4)

9.0

POWDER COATING

POWDER COATING



M1107005



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-1 08/02/12

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



W



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-02-12

(4X)

11.0

D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Knob

B16177B

mf

12.0

D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lock Channel

B 36577

mf

13.0

D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inventory

B 36576

mf

14.0

D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inventory

B 33794

mf

08-02-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:37:31 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING) - UNDER REVIEW

Job Number: 36750

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2372

Quick Release



B37448



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Quick Release

B36698

mf

16.0

D2373

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spring

B26458

mf

17.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pip Pin Assembly

B37070

mf

18.0

AN526C1032R18

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

m4523

mf

19.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

m106167

mf

20.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Washer

m104885

mf

21.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Rivet, Universal Head

m15541

mf

22.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut

m106242

mf 08-02-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 08/03/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:37:31 PM
User: Kim Johnston

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Job Number: 36750

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

mi 3719

mf

24.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw

mi 104156

mf

25.0

NAS679A3W

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut

mi 1463

mf

08-02-14

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D2360

mf

08-03-03

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/3/05 x (4)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 185

8/3/5

50

(4)

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/05

Job Completion



mi 2008/3/05

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

RELEASED07-06-07 **[Signature]****PARTS LIST:**

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

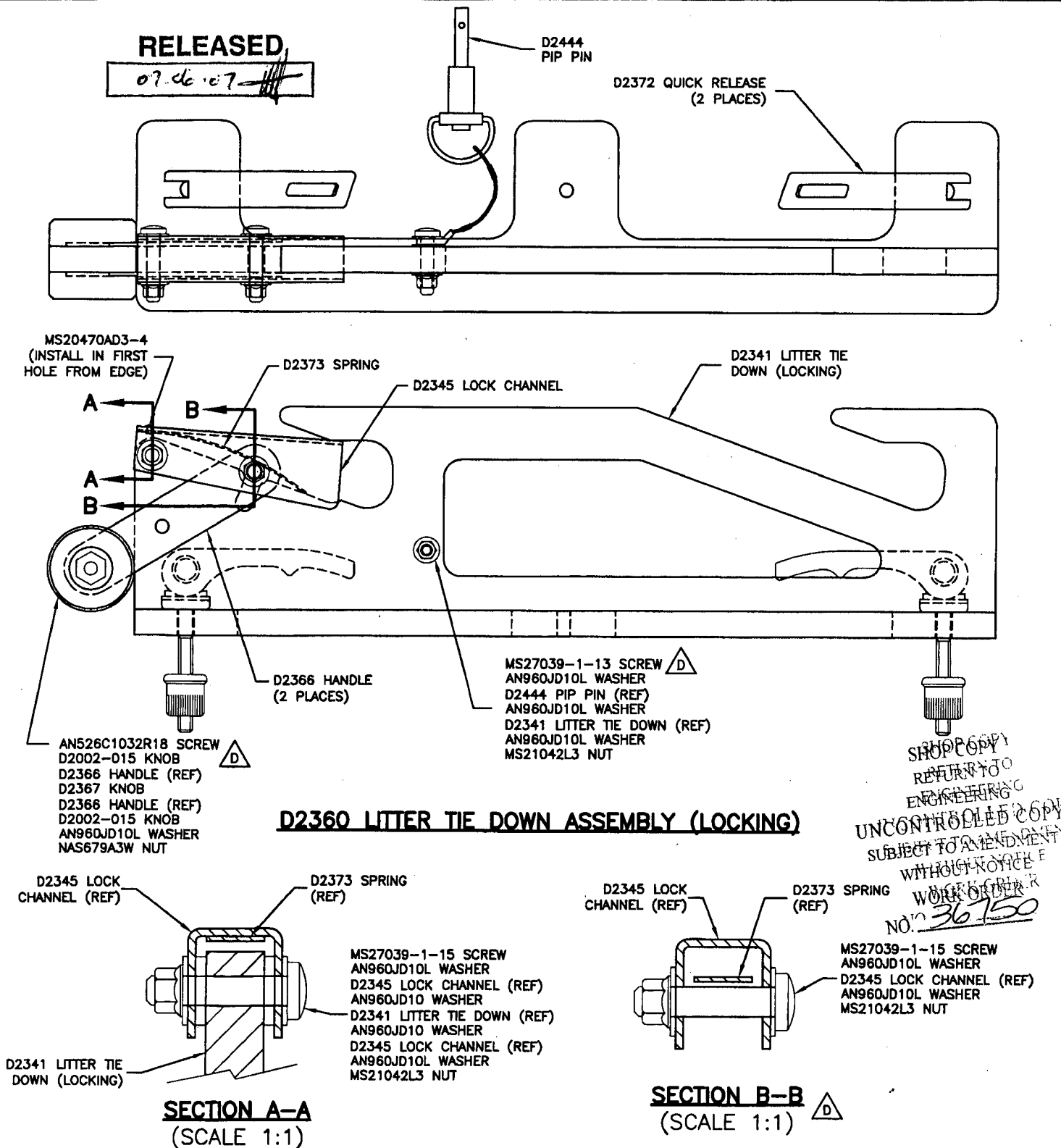
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **36750**

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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06	TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS		



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DART AEROSPACE LTD		Work Order:	36750
Description: Litter Tie Down Bracket (Locking)		Part Number:	D2341
Inspection Dwg: D2341 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

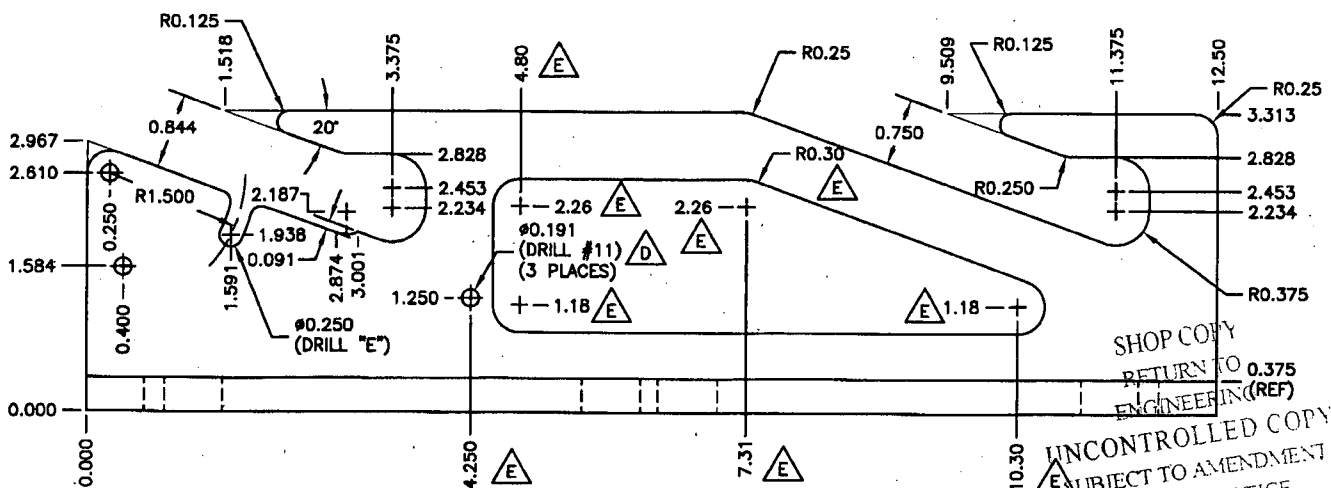
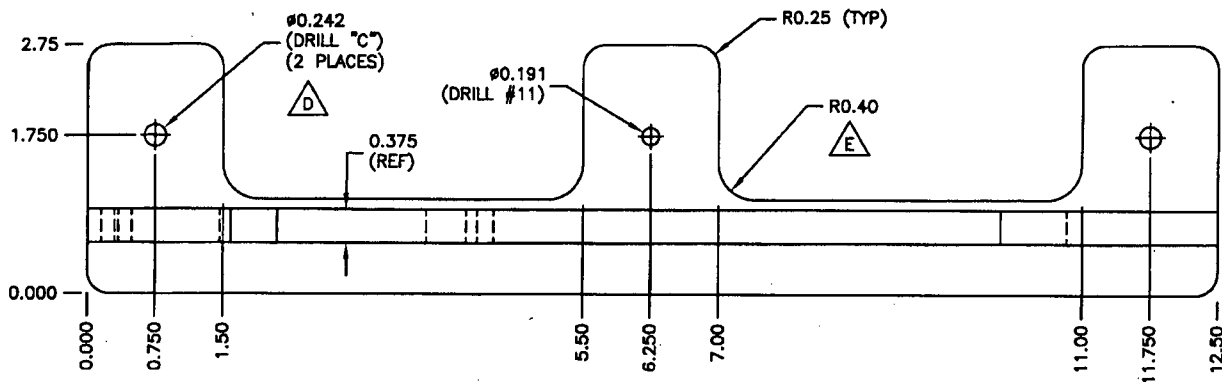
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	+/-0.010	1.503	✓			
1.000	+/-0.010	1.000	✓			
Ø0.242	+0.005/-0.001	.244	✓			
Ø0.191	+0.005/-0.001	.192	✓			
R0.250	+/-0.010	.250	✓			
? 1.700	+/-0.010					
0.750	+/-0.010	.752	✓			
2.750	+/-0.010	2.755	✓			
11.000	+/-0.005	11.000	✓			
5.500	+/-0.010	5.500	✓			
1.584	+/-0.010	1.584	✓			
Ø0.191	+0.005/-0.001	.192	✓			
2.610	+/-0.010	2.609	✓			
0.844	+/-0.010	.845	✓			
1.250	+/-0.010	1.249	✓			
0.750	+/-0.010	.758	✓			
12.500	+/-0.010	12.505	✓			
3.313	+/-0.010	3.313	✓			
4.250	+/-0.010	4.250	✓			
0.400	+/-0.010	.399	✓			

Measured by:	JL	Audited by:	S.F	Prototype Approval:	N/A
Date:	08/02/10	Date:	08/02/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	

DART

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED JH	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION (6061-T6/T651 PER QQ-A-200/B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER



SHOP COPY

RETURN TO 0.375
ENGINEERING (REF)UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 36750

RELEASED

07.06.22

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